

Work Order ID 159934

\*159934\*

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Monday, May 08, 2017 1:59:18 PM

Item ID: D2620 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Skidtube, 206 Skidtube  
 Start Date: 4/25/2017 Start Qty: 20.00 \*20\* Cust Item ID:  
 Required Date: 5/2/2017 Req'd Qty: 20.00 \*20\* Customer:  
 Reference: SCHEDULED/S

Approvals: Process Plan: DAS 21 Date: MAY 08 2017 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: 9-89 Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr             |                      |         |        |              |               |               |                  |                |
| D2620                          | Rev B                    |                      |         |        |              |               |               |                  |                |

100 Skidtubes 0.69  
 \*100\*  
 Skidtubes  
 Skidtubes  
 Memo 2.91  
 1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program  
 206.A and Folio Ft008  
 2- Cut Fwd end of tube as per Dwg D2620

110 QC5- Inspect part completeness to step on W/O 0.00  
 \*110\*  
 QC Memo 0.40  
 Quality Control

JW 17-05-17  
mlb  
20 0 17-05-17

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                          | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty   | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---------------------------------------------------|----------------------|---------|--------|--------------|---------------|-----------------|------------------|----------------|
| 120                            | Identify as per dwg & Stock Location: <u>LG02</u> | 0.00                 |         |        |              |               |                 |                  |                |
| <b>*120*</b>                   |                                                   |                      |         |        |              | <u>20</u>     | <u>17/05/17</u> |                  |                |
| Packaging                      | Memo                                              | 0.20                 |         |        |              |               |                 |                  |                |
| Packaging                      | LOCATION : LG002                                  |                      |         |        |              |               |                 |                  |                |
| 130                            | QC21- Final Inspection - Work Order Release       | 0.00                 |         |        |              |               |                 |                  |                |
| <b>*130*</b>                   |                                                   |                      |         |        |              |               |                 |                  |                |
| QC                             | Memo                                              | 2.00                 |         |        |              |               |                 |                  |                |
| Quality Control                |                                                   |                      |         |        |              |               |                 |                  |                |

DAS  
21  
9-89

MAY 17 2017

# Picklist Print

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Work Order ID: 159934

**\*159934\***

Parent Item: D2620

**\*D2620\***

Parent Item Name: Skidtube, 206 Skidtube

Start Date: 4/25/2017

Required Date: 5/2/2017

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP D02.07.26Change Dwg to rev.B; Updated LocationRF

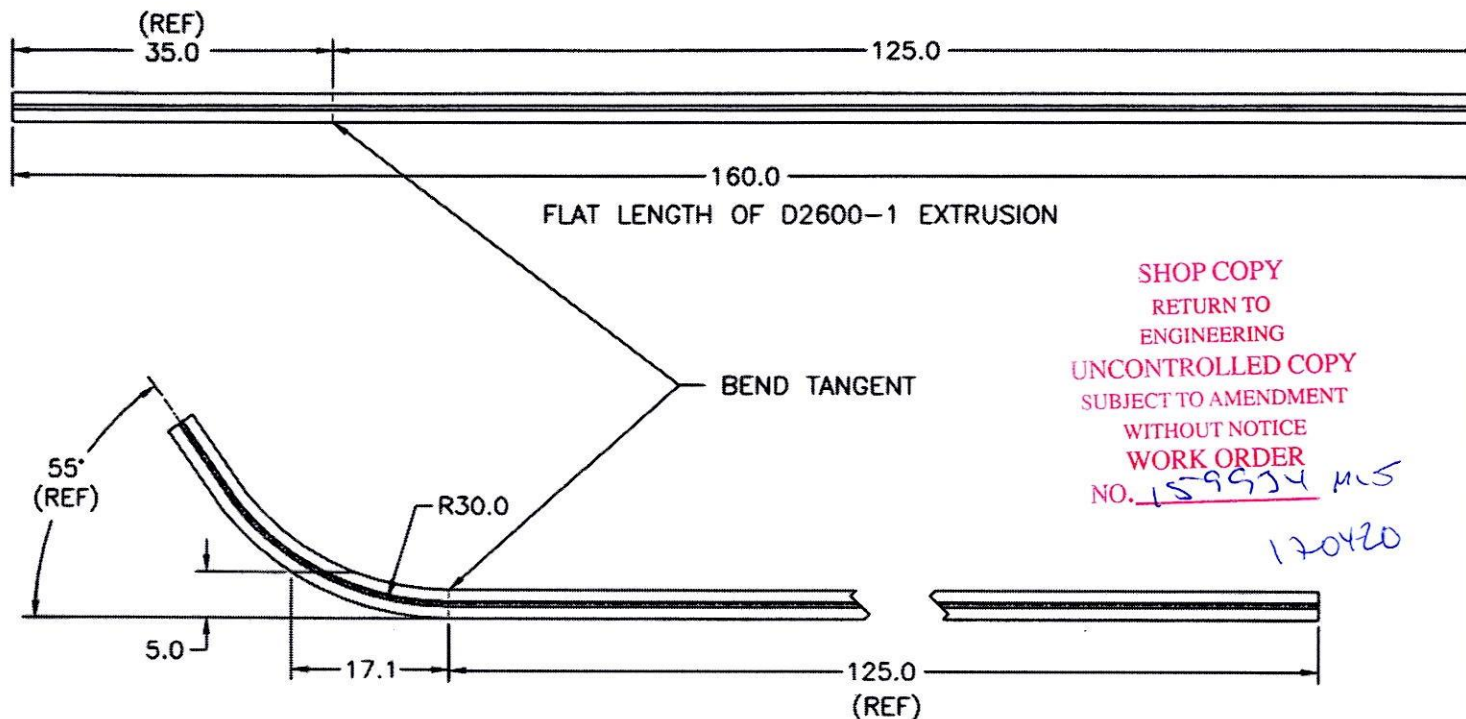
| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2600-1-160                     |                        | Manufactured  | No          |                     |                  | 100             | Each               | 142.0000       | 1           | 20           |               |                |        |
| <b>*D2600-1-160*</b>            |                        |               |             |                     |                  |                 |                    |                | <b>**</b>   |              |               |                |        |
| Extrusion Round 3" 206          |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |

JW 17-05-17

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| HALL     | 138     |          |
| 136919   | 34      |          |
| 141287   | 104     |          |
| LG002    | 4       |          |
| 136919   | 4       |          |

# SPECIFICATION CONTROL DRAWING

## 206 SKIDTUBE BENDING



### DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE  $3.20 \pm 0.200$  IN THE BEND. TUBE WIDTH SHOULD BE  $3.200 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE  $3.15 \pm 0.200$  IN THE BEND. TUBE HEIGHT SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

**DART**



| DESIGN   | DRAWN BY | DART AEROSPACE USA, INC.            |
|----------|----------|-------------------------------------|
| CHECKED  | APPROVED | FAIRCHILD INTERNATIONAL AIRPORT, WA |
| DATE     | DATE     | TITLE                               |
| 99.09.10 | 97.11.07 | 206 SKIDTUBE BENDING CONTROL        |
| A        | 97.09.10 | NEW ISSUE                           |
| B        |          | UPDATE FOR IN-HOUSE BENDING         |
|          |          | SCALE                               |
|          |          | 1:20                                |

**RELEASED**  
44.04.15 DS